

Work Order ID 56417

February 23, 2010 11:46:11 AM



Page 1

Item ID: D3179-041

Accept



Setup Start



Revision ID:

Item Name: Fwd Litter Tie Down

Stop



Start Date: 25/02/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 05/03/2010 Req'd Qty: 6.00

Customer:

Reference:

10.02.23

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3179	Rev C

100



Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut blanks: 12.150" long

0.00

0.00

H.A 10/03/09

6 *0*

110



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1- Mill as per Folio FA297 Rev: *C* & Dwg D3179-1 Rev: *C* ☐ 2-Deburr
per dwg D3179-1

0.00

0.00

H.A 10/03/09

6 *0*

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

H.A 10/03/09

6 *0*

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Start Date: 25/02/2010 Start Qty: 6.00



Required Date: 05/03/2010 Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				6	0		
		SN 10/03/10							
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				26	0		
		HL 10/03/10							
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				6	0		
		BR 10-3-10.							

100

100

100

100

100

100

100

100

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Page 3

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Start Date: 25/02/2010 Start Qty: 6.00

Required Date: 05/03/2010 Req'd Qty: 6.00

Reference:

Accept

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

START TIME:

7:00AM

OVEN TEMPERATURE:

7:30AM FINISH TIME:

320°F

=> 11 10/03/11

(X6) 0

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

BR 10-3-11

(6) 0

180



Small Fab

Small Fab

Small Fab

0.00

Memo

0.00

Assemble as per Dwg D3179

EF 10/03/11 (6)

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Page 4

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Start Date: 25/02/2010 Start Qty: 6.00

Required Date: 05/03/2010 Req'd Qty: 6.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

Scolorin

0.00

16

QC

Memo

Quality Control

200

Identify as per dwg & Stock Location: 225

0.00

0.00

Packaging

Memo

Packaging

10-3-12 (L) SP

210

QC21- Final Inspection - Work Order Release

0.00

0.00

QC

Memo

Quality Control

10/03/16

MF

10-3-12

1870
1871
1872

1873
1874

1875
1876
1877

1878
1879
1880

1881
1882
1883
1884
1885

Picklist Print

February 23, 2010 11:46:10 AM

Page 1

Work Order ID: 56417

Parent Item: D3179-041

Parent Item Name: Fwd Litter Tie Down

Comments: IPP A1 03.01.09 Added Acid etch end alodine RF
IPP Rev:B Added Powder Coat 07-07-04 JLM
IPP Rev:C 08-12-10 add part list DD verified by:JLM

Start Date: 25/02/2010

Required Date: 05/03/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ D2372	Replacement	Mfg/ Manufactured	Bin No	Primary	Last	Route 180	Unit of Each	Qty on 9.0000	Remaining 12.0000	Qty	Date	Status
Quick Release												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	9	
55058	9	

9/5/10/03/11
356453

D2444

Pip Pin Assembly

Manufactured	No		180	Each	13.0000	6.0000

9/5/10/03/11

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	13	
54801	13	

D6201

"T" Extrusion

Manufactured	No		180	f	6.1682	6.3947

6

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
MAT	6.16815	
45500	6.16815	
56424	20.0000	

6.1000^{fr} H.A 10/03/09

Picklist Print

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Page 2

Work Order ID: 56417

Parent Item: D3179-041

Parent Item Name: Fwd Litter Tie Down

Comments: IPP A1 03.01.09 Added Acid etch end alodine RF
 IPP Rev:B Added Powder Coat 07-07-04 JLM
 IPP Rev:C 08-12-10 add part list DD verified by:JLM

Start Date: 25/02/2010

Required Date: 05/03/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS21042L3		Purchased	No			180	Each	2,566.000	6.0000			
Nut												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	2560	
110844	35	
111274	27	
111668	52	
112314	285	
112385	443	
113523	18	
113537	700	
113644	1000	

MS27039-1-13

Purchased

No

180

Each

98.0000

6.0000

Screw

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	98	
105211	3	
110844	95	

Shop Packet Print

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Page 2

Picklist Print

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Page 3

Work Order ID: 56417

Parent Item: D3179-041

Parent Item Name: Fwd Litter Tie Down

Comments: IPP A1 03.01.09 Added Acid etch end alodine RF
 IPP Rev:B Added Powder Coat 07-07-04 JLM
 IPP Rev:C 08-12-10 add part list DD verified by:JLM

Start Date: 25/02/2010

Required Date: 05/03/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ NAS1149D0332J	Replacement	Mfg/ Purchased	Bin No	Primary	Last	Route 100	Unit of Each	Qty on 500.0000	Remaining 18.0000	Qty	Date	Status
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Washer



Handwritten signature and date: 2/23/10

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

100

113644

100

Main Warehouse

ST

400

112794

200

113237

200

Handwritten number: 18

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Shop Packet Print

Page 3

DART AEROSPACE LTD		Work Order: 56417
Description: Fwd Litter Tie Down Bracket		Part Number: D3179-1
Inspection Dwg: D3179	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	1.001	✓			
Ø0.242	+0.005/-0.001	Ø0.243	✓			
R0.40	+/-0.030	R 0.40	✓			
0.375	+/-0.010	0.374	✓			
Ø0.191	+0.005/-0.001	Ø0.193	✓			
1.00	+/-0.030	1.001	✓			
1.70	+/-0.030	1.686	✓			
4.00	+/-0.030	3.980	✓			
1.50	+/-0.030	1.500	✓			
0.750	+/-0.010	0.751	✓			
1.50	+/-0.030	1.500	✓			
10.500	+/-0.010	10.500	✓			
4.250	+/-0.010	4.249	✓			
0.750	+/-0.010	0.750	✓			
1.000	+/-0.010	1.001	✓			
12.00	+/-0.030	12.000	✓			
1.00	+/-0.030	1.000	✓			
8.00	+/-0.030	8.000	✓			
Ø0.191	+0.005/-0.001	Ø0.193	✓			
R0.37	+/-0.030	R0.370	✓			
0.97	+/-0.030	0.967	✓			
1.86	+/-0.030	1.863	✓			
1.750	+/-0.010	1.750	✓			
0.375	+/-0.010	0.375	✓			
2.875	+/-0.010	2.875	✓			
0.500	+/-0.010	0.500	✓			
1.250	+/-0.010	1.249	✓			
1.625	+/-0.010	1.623	✓			
3.31	+/-0.030	3.308	✓			

Measured by: H.A	Audited by: SA	Prototype Approval:	N/A
Date: 10/03/09	Date: 10/03/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.04.05	New Issue	KJ/DD	

DATE: 10-10-1910

NO. 1010

TO: Mr. J. H. ...

FROM: Mr. J. H. ...

SUBJECT: ...

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±1.95 o/p

MS27039-1-13 SCREW
NAS1149D0332J WASHER, 3 PL
MS21042L3 NUT

D2444
PIP PIN

D3179-1 LITTER TIE
DOWN BRACKET

D2372 QUICK
RELEASE
2 PL

 D3179-041 FWD LITTER TIE DOWN BRACKET

NOTES:

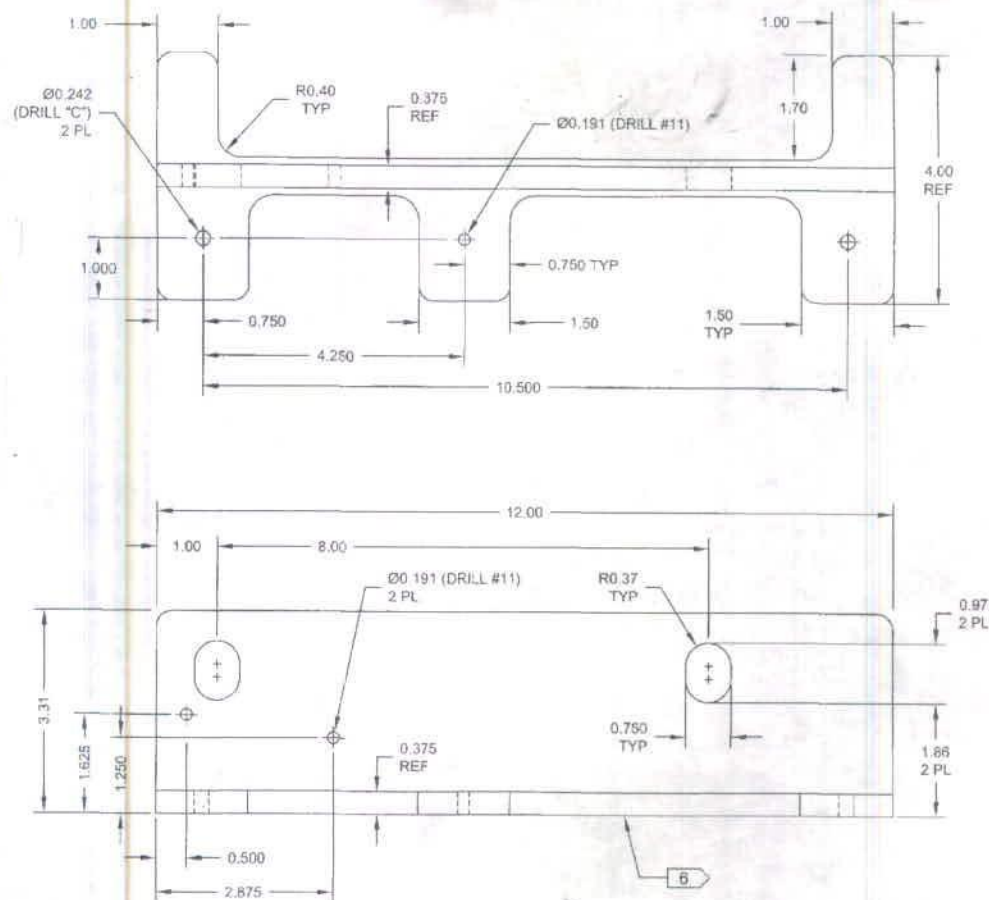
1) D3179-041 WEIGHT: 2.79 lbs

Item	Qty	Part Number	Description
1	X	D3179-041	FWD LITTER TIE DOWN
2	2	D2372	QUICK RELEASE
3	1	D2444	PIP PIN
4	1	D3179-1	LITTER TIE DOWN BRACKET
5	1	MS21042L3	NUT
6	1	MS27039-1-13	SCREW
7	3	NAS1149D0332J	WASHER (OR AN860JD10L)

REUSED
08/11/07

C	ADD D3179-041 & PART LIST (ZN B6-1, D2-1); D3179-1 WAS D3179 (ZN A5-2); REMOVE ENGRAVE P/N	RF	08.11.07
B	REFORMAT DRAWING; FINISH WAS ANODIZE	DC	07.06.06
A	NEW ISSUE	RF	02.12.09
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO	REV. C
MFG. APPR.		D3179	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		LITTER TIE DOWN BRACKET	NTS
DATE	08.11.07	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD. THIS DOCUMENT IS UNCLASSIFIED AND IS AVAILABLE FOR REPRODUCTION IN WHOLE OR IN PART WITHOUT PERMISSION FROM DART AEROSPACE LTD. UNLESS OTHERWISE SPECIFIED IN THE DOCUMENT.</small>	

t 1125 o/n



D3179-1 LITTER TIE DOWN BRACKET

NOTES:

- 1) MATERIAL: MAKE FROM D6201-012 EXTRUSION (6061-T6/T6511 PER QQ-A-200/8)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3179-1 USING FINE POINT PERMANENT INK MARKER ON THE BOTTOM FACE
- 7) WEIGHT: 2.3 lbs

RELEASED

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED:	PH	DRAWING NO.	REV. C
MFG. APPR.		D3179	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		LITTER TIE DOWN BRACKET	NTS
DATE	08.11.07	COPYRIGHT © 1996 BY DART AEROSPACE LTD	

